

Work Order ID 124099

September-11-14 11:54:21 AM

124099

Page 1

Item ID: D3536-25

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Gasket Center

Stop

NS2

Start Date: 9/10/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 9/10/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: MLSDate: 14-09-11

Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3536	Rev A

100

0.00

DAS

100

FLOW WATER JET

Waterjet

0.00

23

9-89

14-09-18

130

FLOW CNC Waterjet

Memo 0.00
1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A. 2.
Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

DAS

110

QC

0.00

23

9-89

14-09-18

Quality Control

120

QC8- Inspect parts - second check

0.00

DAS

38

9-89

120

QC

0.00

84

9-89

14-09-18

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other		
NCR No. _____							

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Bending
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Centre Not Concentric
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Cracks
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Crimp/Kink/Ripple/Wave
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Cuffs
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Crushing
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Heat Treat
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Inspection Strip in Tube
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Marks/Chatter
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Turning Sequence
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Wave/Twist in Tube
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Bend
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	BOM/Route
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Broken/Damage/Defect
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Burrs
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Contamination
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Countersink
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Cut Too Short
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Drawing
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Drill Holes
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Finish
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Fit/Function
<input type="checkbox"/>				Folio/Program
<input type="checkbox"/>				Grain
<input type="checkbox"/>				Hardware
<input type="checkbox"/>				Inspection Incomplete/Unqualified
<input type="checkbox"/>				Instructions Incomplete/Unclear
<input type="checkbox"/>				Misaligned/off center
<input type="checkbox"/>				Mislabeled
<input type="checkbox"/>				Misread
<input type="checkbox"/>				Off-set
<input type="checkbox"/>				Out of Calibration
<input type="checkbox"/>				Out of Sequence
<input type="checkbox"/>				Outside Dimensions
<input type="checkbox"/>				Over/Under tolerance
<input type="checkbox"/>				Part Incorrect
<input type="checkbox"/>				Part Lost/Missing
<input type="checkbox"/>				Part Moved
<input type="checkbox"/>				Positioned Wrong
<input type="checkbox"/>				Power Loss/Surge
<input type="checkbox"/>				Pressure/Forced
<input type="checkbox"/>				Set-up
<input type="checkbox"/>				Temperature/Cure
<input type="checkbox"/>				Weld
<input type="checkbox"/>				Wrong Stock Pulled
<input type="checkbox"/>				Other

Work Order ID 124099

September-11-14 11:54:21 AM

124099

Page 2

Item ID: D3536-25

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Gasket Center

Stop

NS2

Start Date: 9/10/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 9/10/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging	Identify as per dwg & Stock Location: <u>FP-06</u>	0.00				X13	0	11	10/01/12
Packaging	Memo	0.00							

140 *140* QC	QC21- Final Inspection - Work Order Release	0.00	
Quality Control	Memo	0.00	

MLJ 14-09-22

MLJ 14-09-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
 Scrap
 Use-as-is
 Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube
 Machining
 Thermoforming
 Large Fab

Crosstube
 Small Fab
 Finishing
 Composite

Water Jet
 Prod. Eng. Coor.
 Rec/Store/Packaging
 Supplier

Engineering
 Quality
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General				
Bending	Bend				
Centre Not Concentric	BOM/Route				
Cracks	Broken/Damage/Defect				
Crimp/Kink/Ripple/Wave	Burrs				
Cuffs	Contamination				
Crushing	Countersink				
Heat Treat	Cut Too Short				
Inspection Strip in Tube	Drawing				
Marks/Chatter	Drill Holes				
Turning Sequence	Finish				
Wave/Twist in Tube	Fit/Function				
	Folio/Program				
	Grain				
	Hardware				
	Inspection Incomplete/Unqualified				
	Instructions Incomplete/Unclear				
	Misaligned/off center				
	Mislabeled				
	Misread				
	Off-set				
	Out of Calibration				
	Out of Sequence				

Picklist Print

September-11-14 11:54:20 AM

Page 1

Work Order ID: 124099

124099

Parent Item: D3536-25

D3536-25

Parent Item Name: Gasket Center

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063	Purchased	No				100	sf	328.1001	0.5956	5.294222	9	9-89	DAS 23

MNEO60S.063

NEOPRENE SHEET 0.063

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT052	328.1001	
M126546	2.3	
M128339	325.8001	128339

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>						
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector			
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process														
Supplier														
Training														
Transport														
Unapproved														
FAULT CATEGORY														
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function		<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence						<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	<input type="checkbox"/> Other

DART AEROSPACE LTD	Work Order:	124099
Description: Gasket	Part Number:	D3536-25
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

~~DAS~~

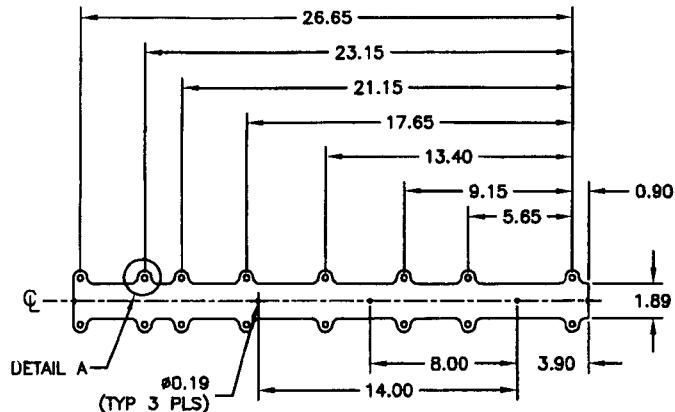
38

Measured by:	23 9-89	Audited by:	9-89	Prototype Approval:	N/A
Date:	14-09-18	Date:	14-9-89	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	EE

DART

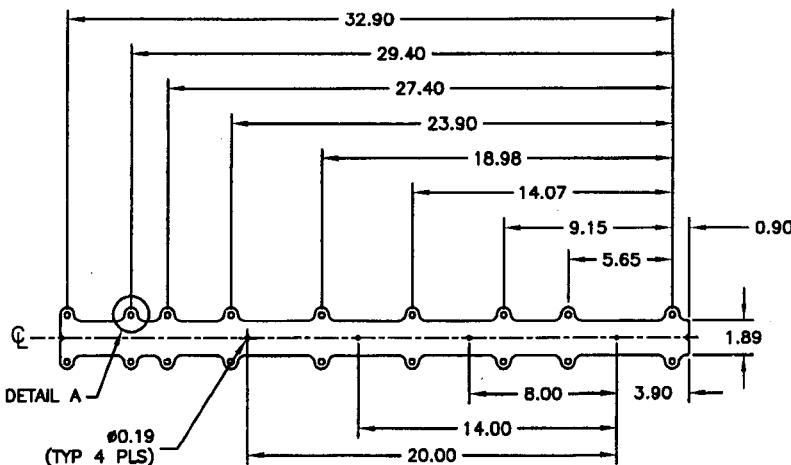
09.02.12



D3536-11 GASKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 124099 MLS

14-09-11



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

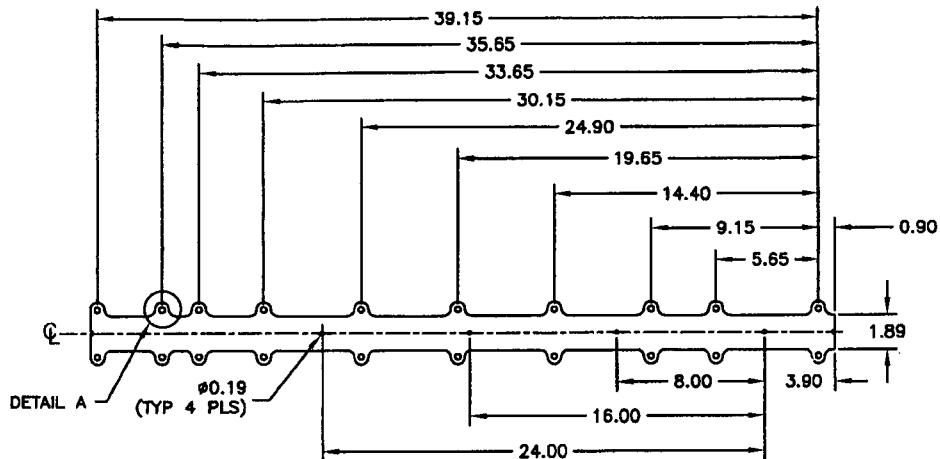
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Copyright © 2006 by DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	CB	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3536
DATE	TITLE	REV. A
06.10.25	GASKET	SHEET 1 OF 6
A	06.10.25	SCALE 1:10
	NEW ISSUE	

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

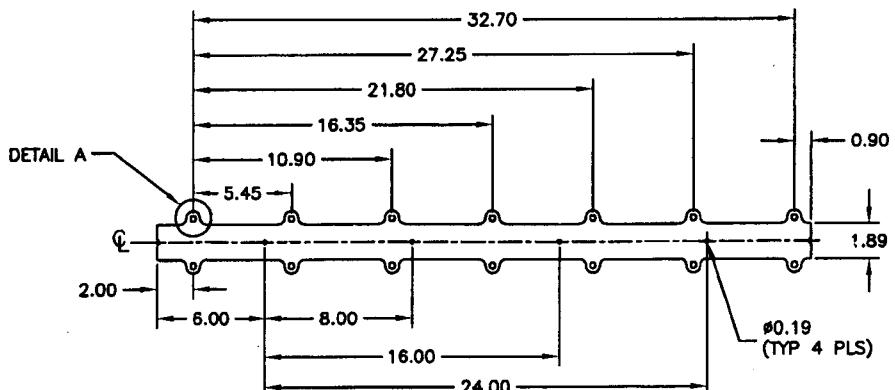
Copyright © 2006 by DART AEROSPACE USA, INC.



D3536-15 GASKET

07.02.12
H

DART



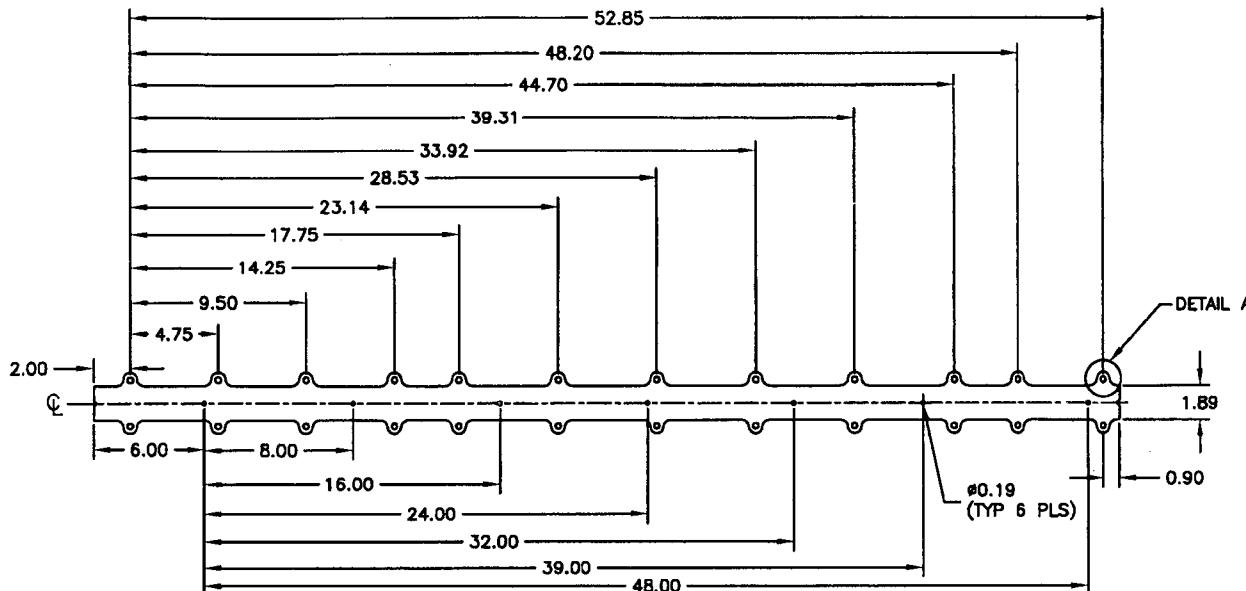
D3536-21 GASKET

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED H	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	REV. A SHEET 2 OF 6 SCALE 1:10

DART

07.02.12
RELEASER

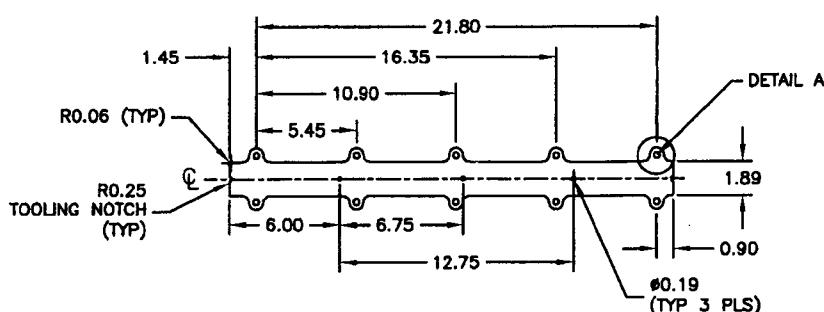
DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HEDLOCK, WA
CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25		TITLE GASKET



D3536-23 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

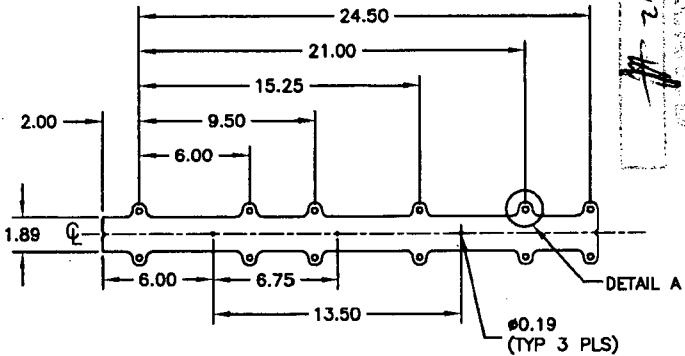


D3536-25 GASKET

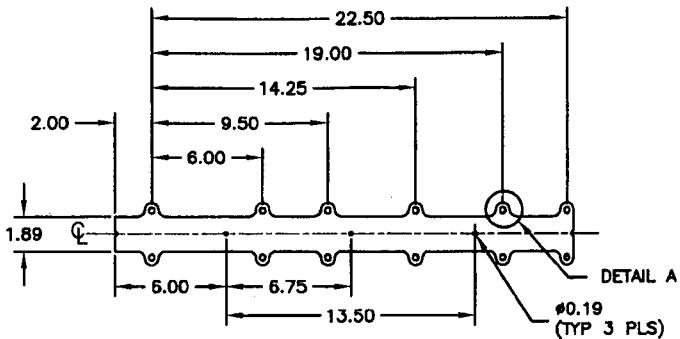
DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	REV. A SHEET 4 OF 6 SCALE 1:10

07.02.12 *[Signature]*



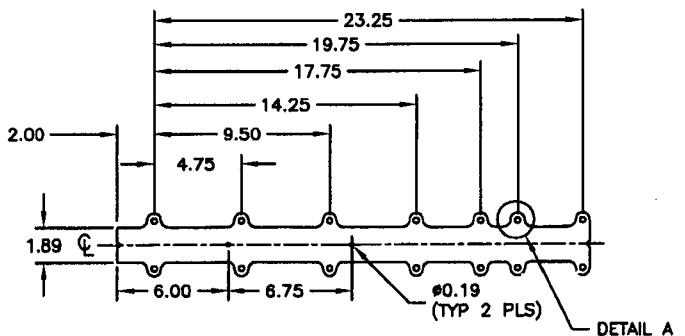
D3536-33 GASKET



D3536-31 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

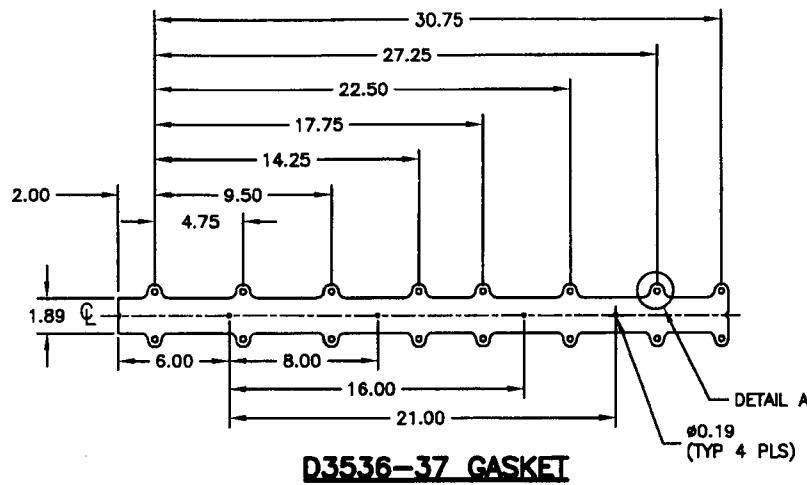


D3536-35 GASKET

DART

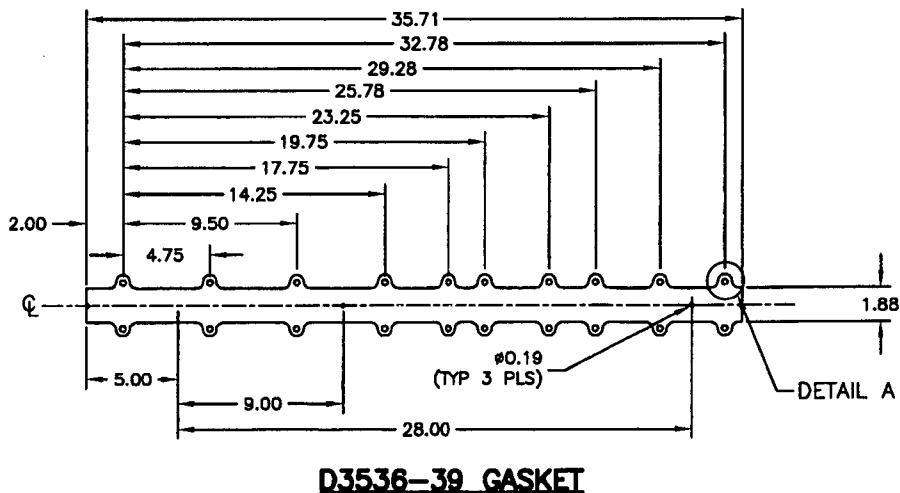
DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	REV. A SHEET 5 OF 6 SCALE 1:10

07.02.12
[Signature]



NOTE:

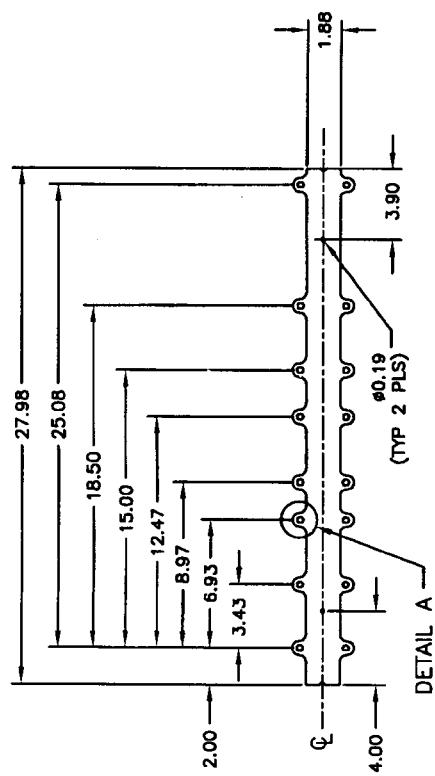
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



DART

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3536	REV. A SHEET 6 OF 6
DATE 06.10.25		TITLE GASKET	SCALE 1:10

07.02.12 *CH*

**D3536-41 GASKET**

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S-063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI Q18 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

Copyright © 2006 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.